

Work Order ID 68571

Page 1

Monday, April 18, 2011 11:33:01 AM

Item ID: D3204-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube

Start Date: 4/18/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 11-04-18

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3204

Rev A1

100

0.00



Hardinge CNC LATHE SMALL

Hardinge

Memo

0.00

Hardinge CNC Lathe Small

1-Turn tube as per Folio FA356 and Dwg D3204-2-Deburr

11/5/17

10

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

11/5/17

10

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

11-5-17

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Setup Start



Revision ID:

Stop



Item Name: Tube

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Cust Item ID:

Required Date: 4/21/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Stop



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *BK*

0.00



Packaging

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****

Pl 11-05-17

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*11/5/18**ME**11-05-17*

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Picklist Print

Monday, April 18, 2011 11:33:07 AM

Page 1

Work Order ID: 68571



Parent Item: D3204-1



Parent Item Name: Tube

Start Date: 4/18/2011

Required Date: 4/21/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: ☐B☐04.06.09☐Change Step 6; remove Steps 7 & 8☐KJ/RF☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.750W.125 		Purchased	No			100	f	8.1600	0.52	5.473684			
6061-T6 RD Tube .750 x .125W													

Location

MAT015

111409

Loc Qty

8.16

8.16

Loc Code

5.2 PR

SA 11/5/17

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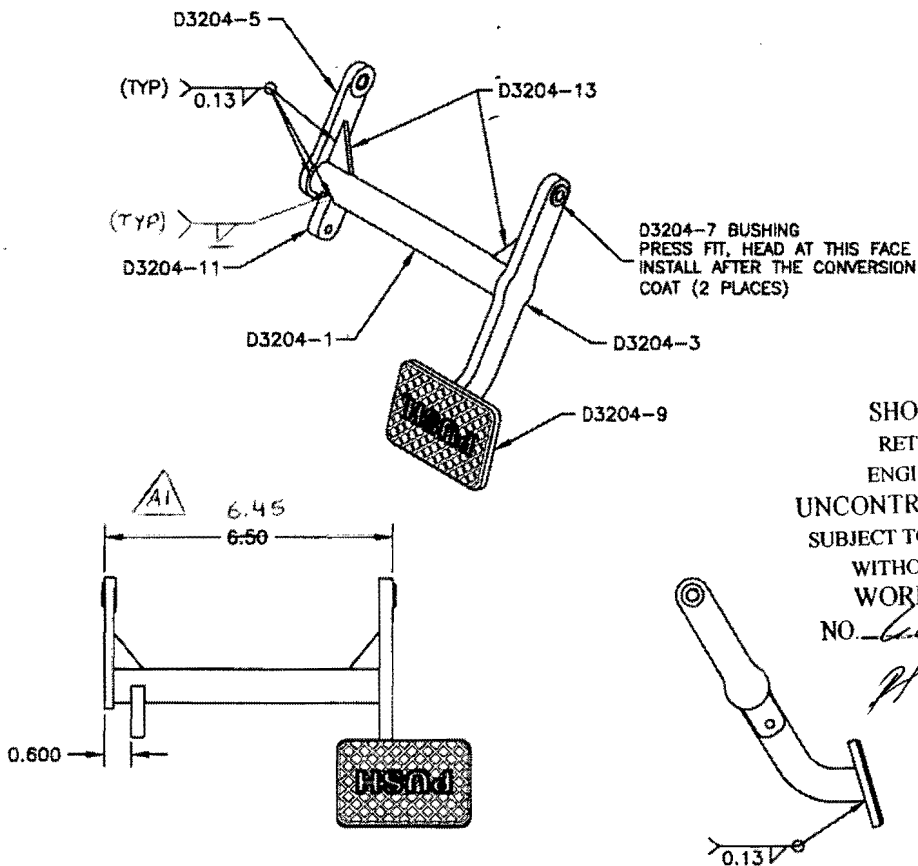
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3204	REV. A SHEET 1 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS
A	04.01.27	NEW ISSUE	
A1	05.07.15	6.45 WAS 6.50	

RELEASED
04.04.30



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 08571
2/11/04-18

D3204-041 RELEASE PEDAL ASSEMBLY

NOTES

- 1) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 2) MATERIAL: 6061-T6 OR -T62 (QQ-A-200/8) 0.750 OD x 0.125 WALL (M6061T6T0.75W.125)
- 3) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8) BAR (M6061T6B)
- 4) MATERIAL: AISI 303 SS (M303R)
- 5) MATERIAL: 6061 (QQ-A-250/11) SHEET 0.125 THICK (M6061T6S.125)
- 6) ENGRAVE "PUSH" USING 0.5" HIGH LETTERS TO DEPTH OF 0.010 TO 0.020
ENGRAVE DART P/N USING 0.125 LETTERS TO MAX DEPTH OF 0.010
- 7) WELD ASSEMBLY PER QSI 004
- 8) CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 9) POWDER COAT ASSEMBLY GREY SANDTEX (REF. 4.3.5.6) PER QSI 005 4.3
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 11) ALL DIMENSIONS ARE INCHES

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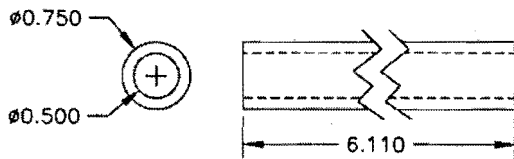
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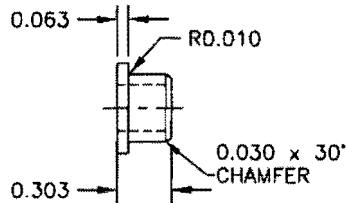


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3204	REV. A SHEET 2 OF 3
DATE 04.01.27		TITLE RELEASE PEDAL ASSEMBLY	SCALE NTS

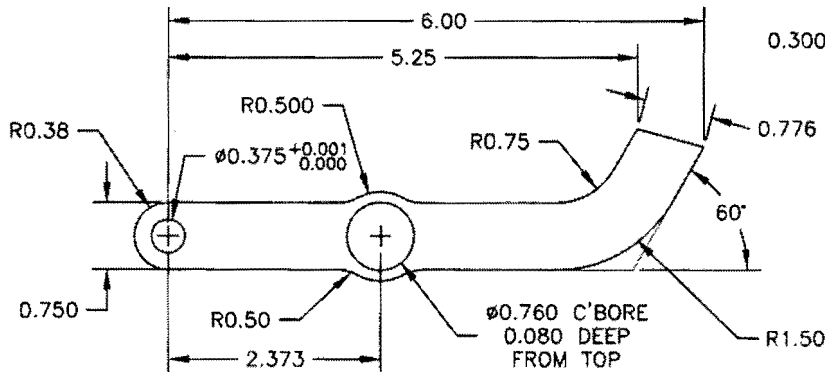
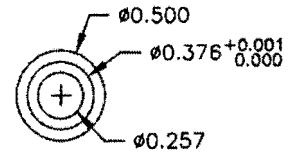
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04.04.05



2 D3204-1 TUBE
SCALE 1:2

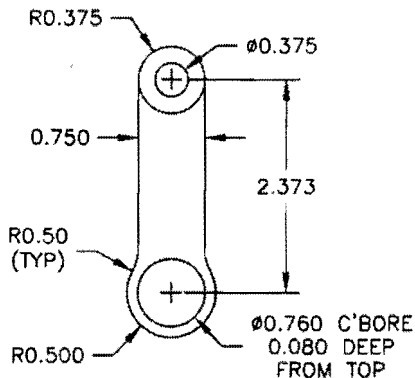


4 D3204-7 BUSHING
SCALE 1:1

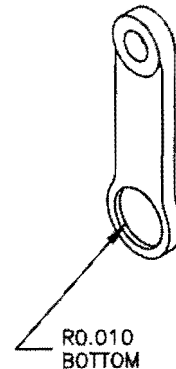
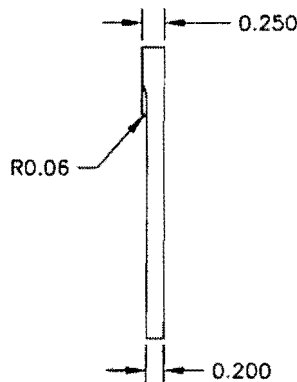


3 D3204-3 ARM
SCALE 1:2

w/06 8571



3 D3204-5 ARM
SCALE 1:2



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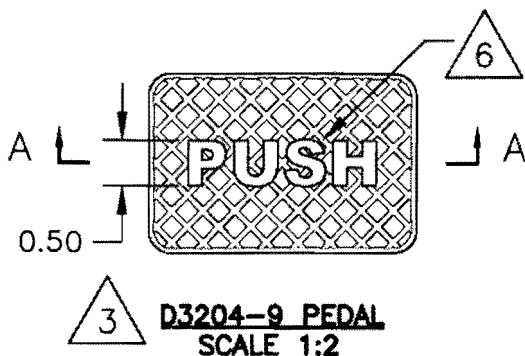
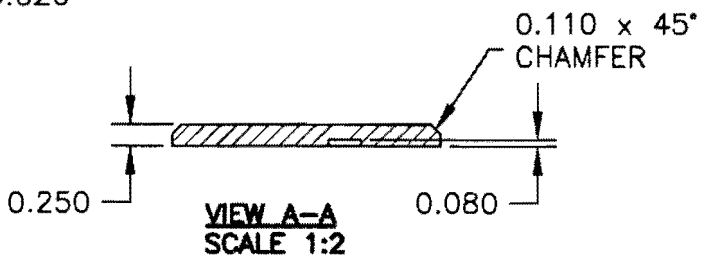
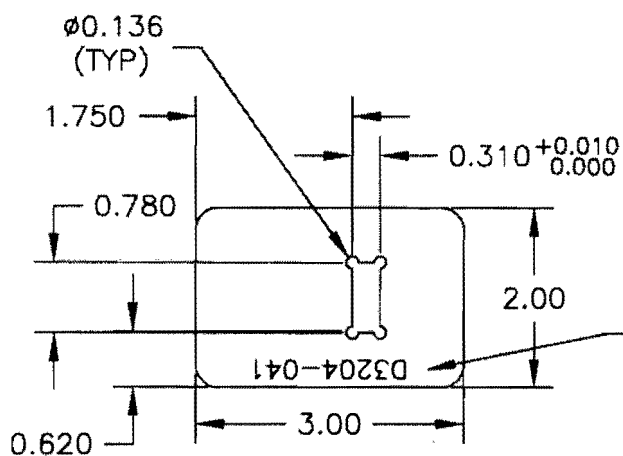
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w/o 68571

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